

Shg 15/03

Work Order ID 66401

Monday, February 14, 2011 11:11:37 AM

Page 1

Item ID: D2646

Accept

Revision ID:

Item Name: Aft Cap

Start Date: 2/15/2011 Start Qty: 4.00

Required Date: 2/28/2011 Req'd Qty: 4.00

Reference: Rework

Approvals:

Process Plan:

Date: 11-02-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2646

Rev C

120

QC6- Inspect dimensions to drawing

0.00



QC

Quality Control

Memo

0.00

130

0.00



Small Fab

Small Fab

Small Fab

Memo

0.00

PULL FROM STOCK D2646UP X 4 B63830

1-Drill using DT8026 as per Dwg D2646. 2-Open holes to 297 as per Dwg

D2646 03-Debur

N/A

11 03 08 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66401

Monday, February 14, 2011 11:11:37 AM



Page 2

Item ID: D2646

Accept



Setup Start



Revision ID:

Item Name: Aft Cap

Stop



Start Date: 2/15/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/28/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							
150 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo	0.00							
155 	Spray Painting per QSI005 4.2	0.00							
SprayPaint Spray Painting	Memo Prime Delfleet Blue : B 115967 Paint Delfleet Blue : B 115509 Clear Delfleet : B 115949	0.00							

N/A

11 03 08 (4)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 66401

Monday, February 14, 2011 11:11:37 AM



Page 3

Item ID: D2646

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Cap

Start Date: 2/15/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/28/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

RT 11-03-09

180



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

✓ Install inserts as per Dwg D2646

4 of 11/03/15

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 11/03/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 66401

Monday, February 14, 2011 11:11:37 AM



Page 4

Item ID: D2646

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Cap

Start Date: 2/15/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/28/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Identify as per dwg & Stock Location: FP-4

0.00



Packaging

Memo

0.00

Packaging

4 0 Jell 11/03/15

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/15 J
MP
11-03-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, February 14, 2011 11:11:35 AM

Page 1

Work Order ID: 66401

Parent Item: D2646

Parent Item Name: Aft Cap



Start Date: 2/15/2011

Required Date: 2/28/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: G05.08.22 Hole size revised in Step 5 KJ/JLM
 IPP Rev:H Changed Inserts 07-02-19 JLM
 IPP rev I changed inserts 07.06.11 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS7-1032-130		Purchased	No			110	Each	1,944.000	2	8			
Insert													

Location

Loc Qty

Loc Code

FP	21	
115079	21	
ST282	1923	
113238	17	
115502	500	
115581	406	
116800	1000	

D2646UP		Manufactured	No				Each	4.0000		4			
Aft Cap-unpainted													

Location

Loc Qty

Loc Code

FP	4	
63830	4	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

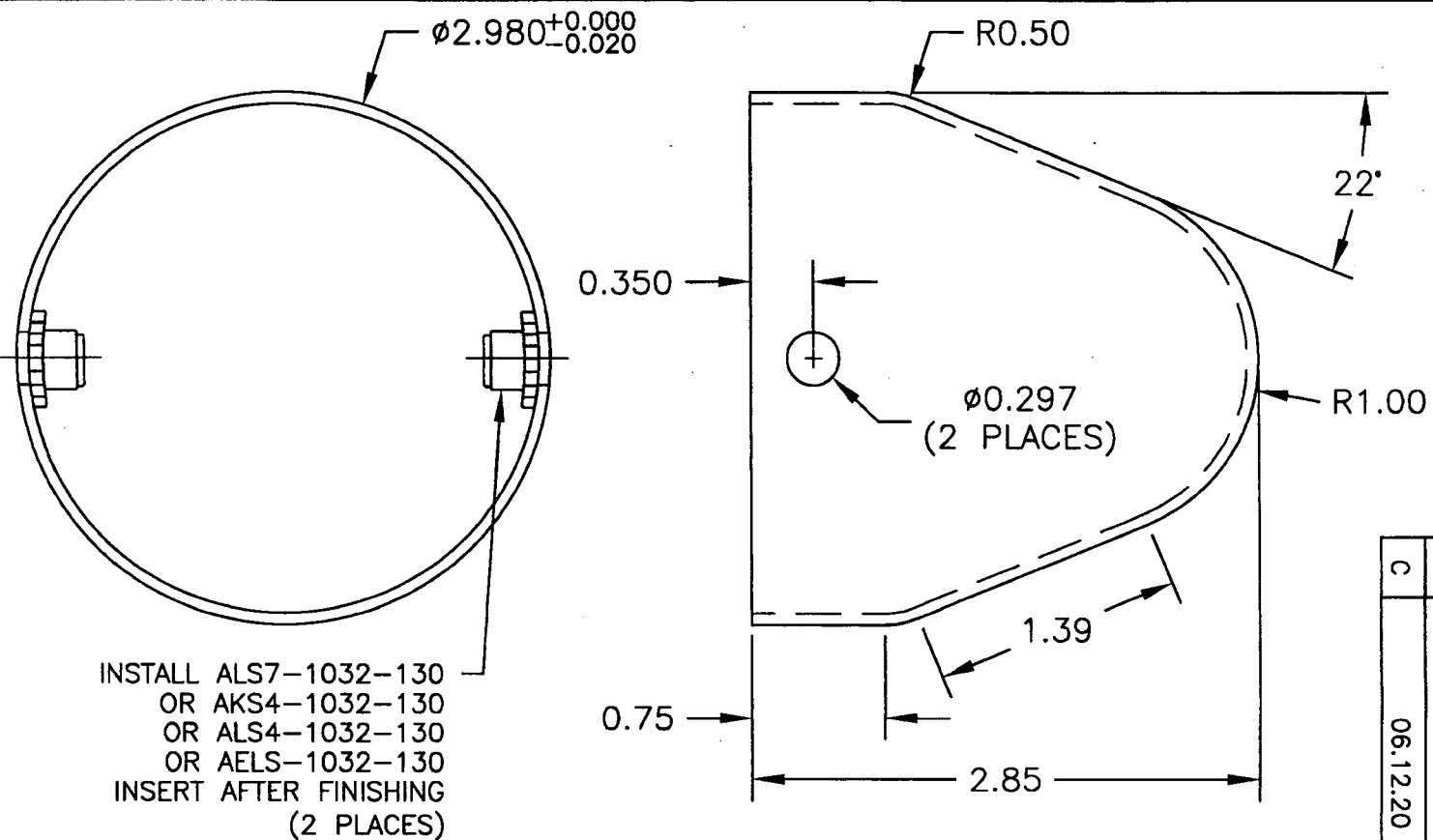
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN	DS	DRAWN BY	PH	DART AEROSPACE USA, INC.
				PORT HADLOCK, WA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2646
DATE	06.12.20			TITLE AFT CAP
				SCALE 1:1
A	97.03.25			NEW ISSUE
B	05.04.01			CHANGE TO CLOSED INSERTS
C	06.12.20			CHANGE TO OPEN ENDED INSERTS



D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

07.02.12

#66401

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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